

Date: Thursday, 04/12/2008 9:10:55 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WINDOW
<b>Job Number</b> : 43903	
<b>Estimate Number</b> : 11176	
<b>P.O. Number</b> :	<b>Part Number</b> : D32903
<b>This Issue</b> : 04/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3290 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 42413	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/12/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JCD 08.12.04</u>	
<b>Comment</b> :	
Est. A 04.08.18 New issue KJ/RF	
Est. B 06.05.09 Ecn 798 EC	
Est. C 07.05.29 Thermoform in-house DL	
Est. D 07.09.28 rev C dwg EC verified by: DD	
Est. E 07.11.28 Add -Hand finish deburring DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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38



**Comment:** Qty.: 3.1500 sf(s)/Unit Total : 31.5000 sf(s)  
 Polycast II or plexiglass G .125"

109570 X 3 = 9.45  
 110115 X 9 = 98.35

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3290

Dwg Rev: CProg Rev: C

IB 8-12-16

(12)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-12-16

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/12/16

(x12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: WINDOW

Job Number: 43903

Part Number: D32903

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Without removing protective skin  
remove sharp edge by degurring.

BB 08/12/16 X12

6.0 THERMOFORMING

THERMOFORMING MACHINE



Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. C

Folio Rev. B

2-Engrave part# & batch#,  
(D3290-3)

BB 08/12/16 X12

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances

BB 08/12/16 X12

8.0 QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/12/17 X12

9.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

BB 08/12/17

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/17 X12

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57216

BB 08/12/17 X12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: WINDOW

Job Number: 43903

Part Number: D32903

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/19 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-12-18*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

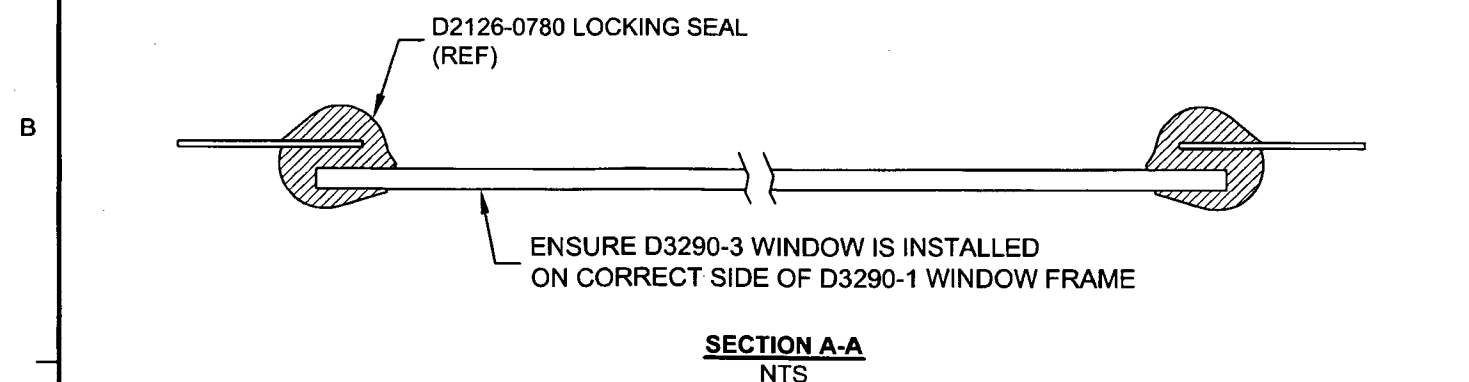
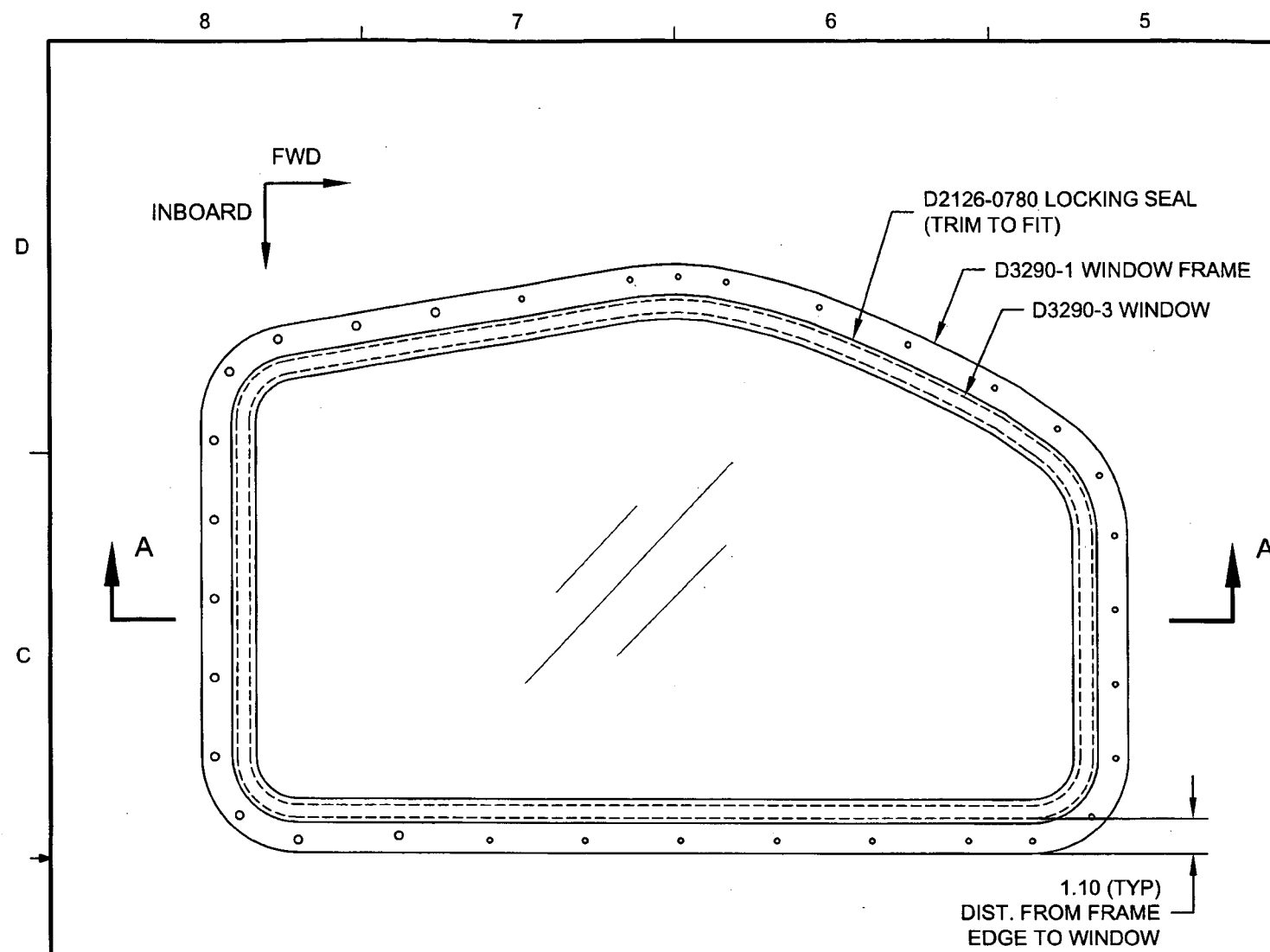
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

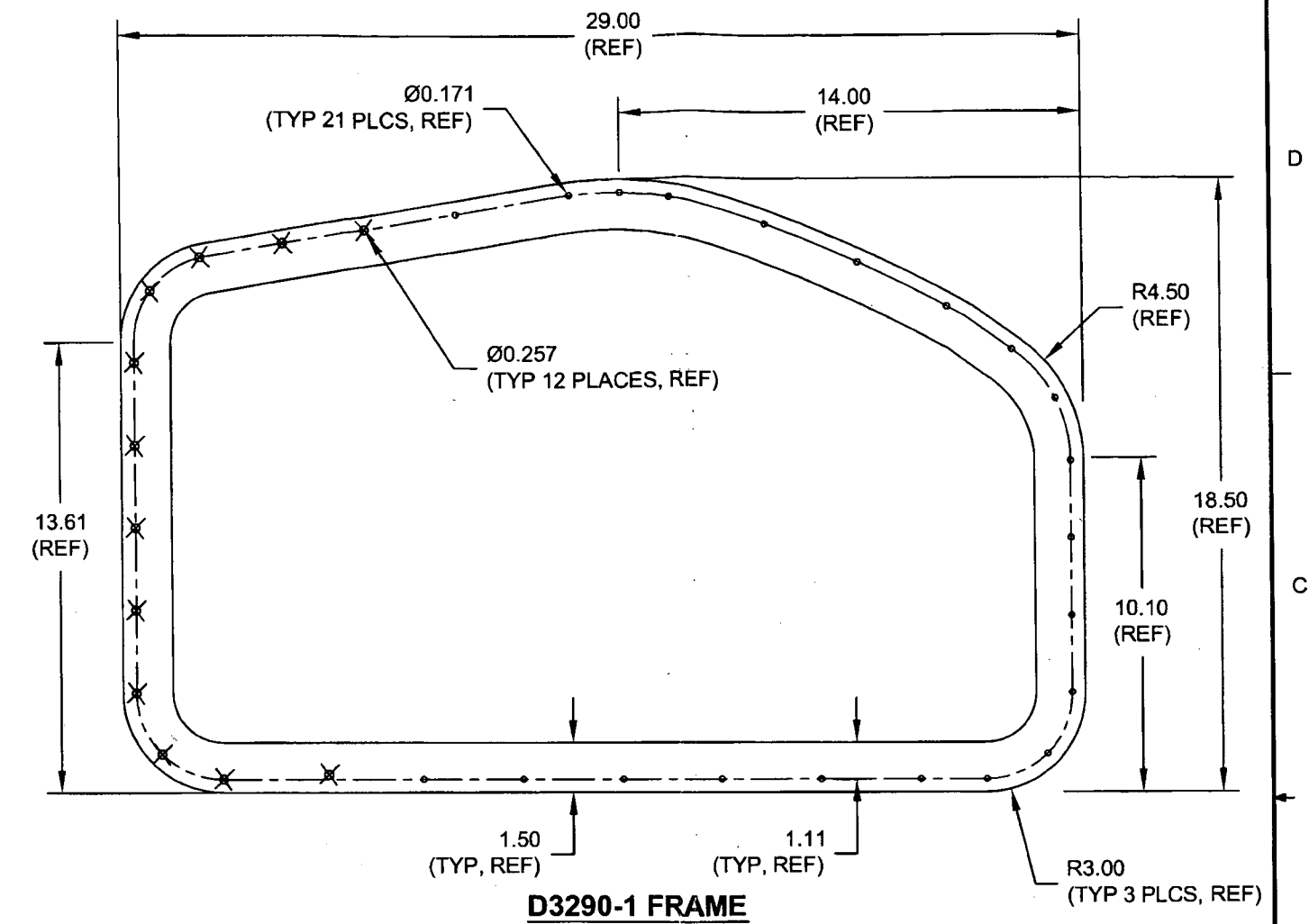




### D3290-041 REPLACEMENT WINDOW ASSEMBLY

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

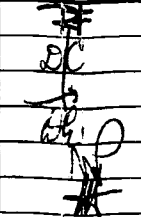
**GENERAL NOTES:**  
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED

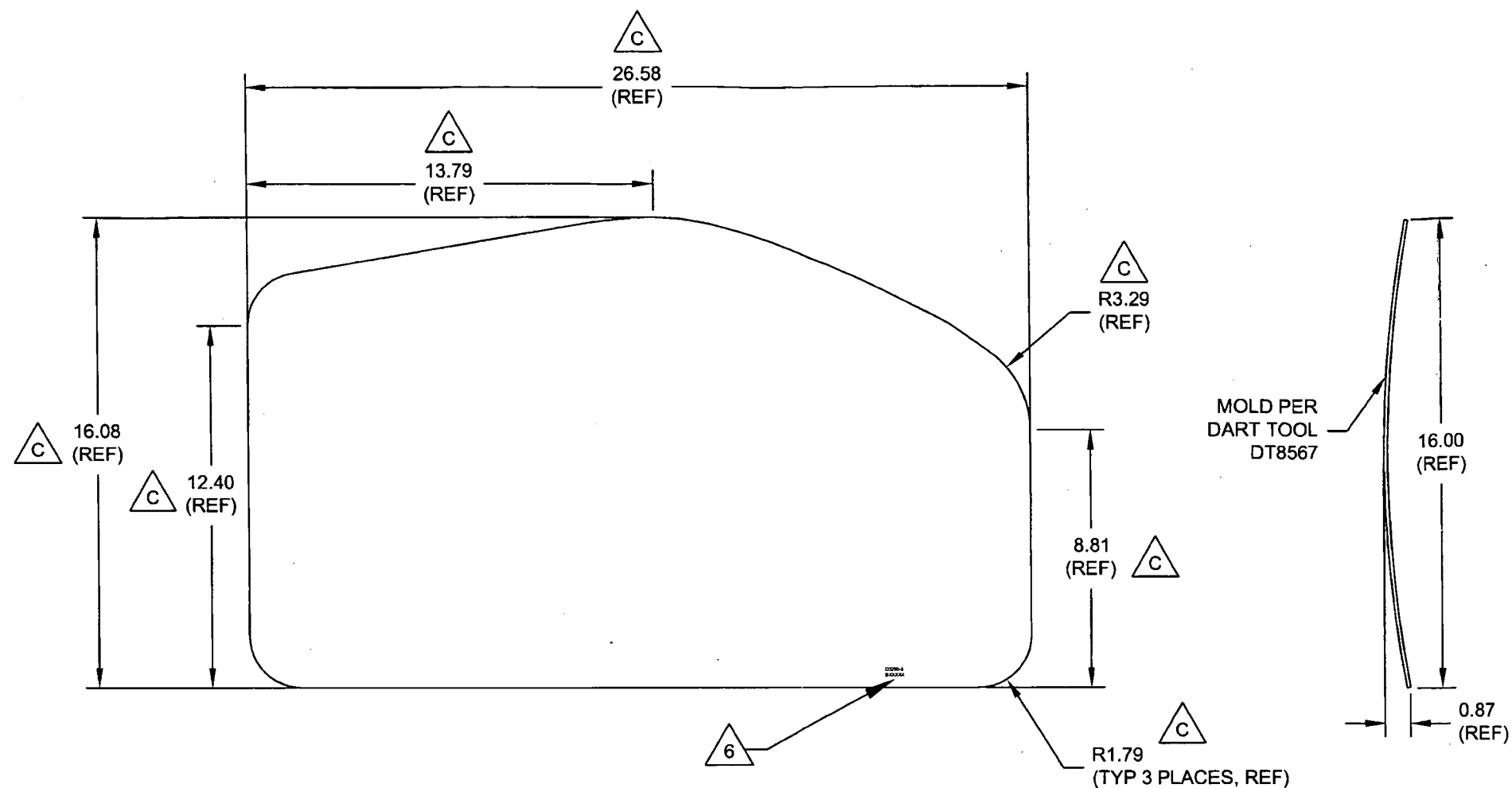


- D3290-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
  - 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
  - 5) WEIGHT: 0.47 LBS

**RELEASED**  
07.09.22 #

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WITHOUT NOTICE  
WORK ORDER NO. 43903

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	REPLACEMENT WINDOW ASSEMBLY	1:5	
DATE	07.07.24		
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### D3290-3 WINDOW

#### D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

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WORK ORDER  
NO. 43903

DESIGN	<b>D3290-3</b>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>DF</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DF</i>	DRAWING NO. REV. C
MFG. APPR.	<i>DF</i>	D3290 SHEET 2 OF 2
APPROVED	<i>DF</i>	TITLE SCALE
DE APPR.	<i>DF</i>	REPLACEMENT WINDOW ASSEMBLY 1:5
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